

Date: Monday, 21/07/2008 10:53:43 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : GROUND PLATE
Job Number : 40688	
Estimate Number : 13282	
P.O. Number :	Part Number : D37971
This Issue : 21/07/2008 S.O. No. :	Drawing Number : D3797 REVA
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 38906	Material :
Written By :	Due Date : 01/08/2008 Qty: 4 Um: Each
Checked & Approved By : <u>JUL 08 1216</u>	
Comment : Est Rev:A 08-04-25 new issue DD verified by:ec Est Rev:B 08-07-14 revA as per dwg DD verified by:ec	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S050	6061-T6 .050 Sheet
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Comment: Qty.: 0.4797 sf(s)/Unit Total : 1.9190 sf(s)
 6061T6 aluminium sheet .050" thick
 (M6061T6S050)
 Batch: 104186 B8-8-13

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3797
 Dwg Rev: A B8-8-13
 Prog Rev: A
 2- Deburr if necessary B8-8-13

(5)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

8 08/08/13 (X5)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock
 Location: _____

51/1016

08/08/13 (X5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 21/07/2008 10:53:43 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GROUND PLATE

Job Number: 40688

Part Number: D37971

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(5)

Comment: FINAL INSPECTION/W/O RELEASE

08/08/14

Job Completion



MF 08-08-13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 40688
Description: GROUND PLATE		Part Number: D3797-1
Inspection Dwg: D3797-1 Rev: A		Page 1 of 1

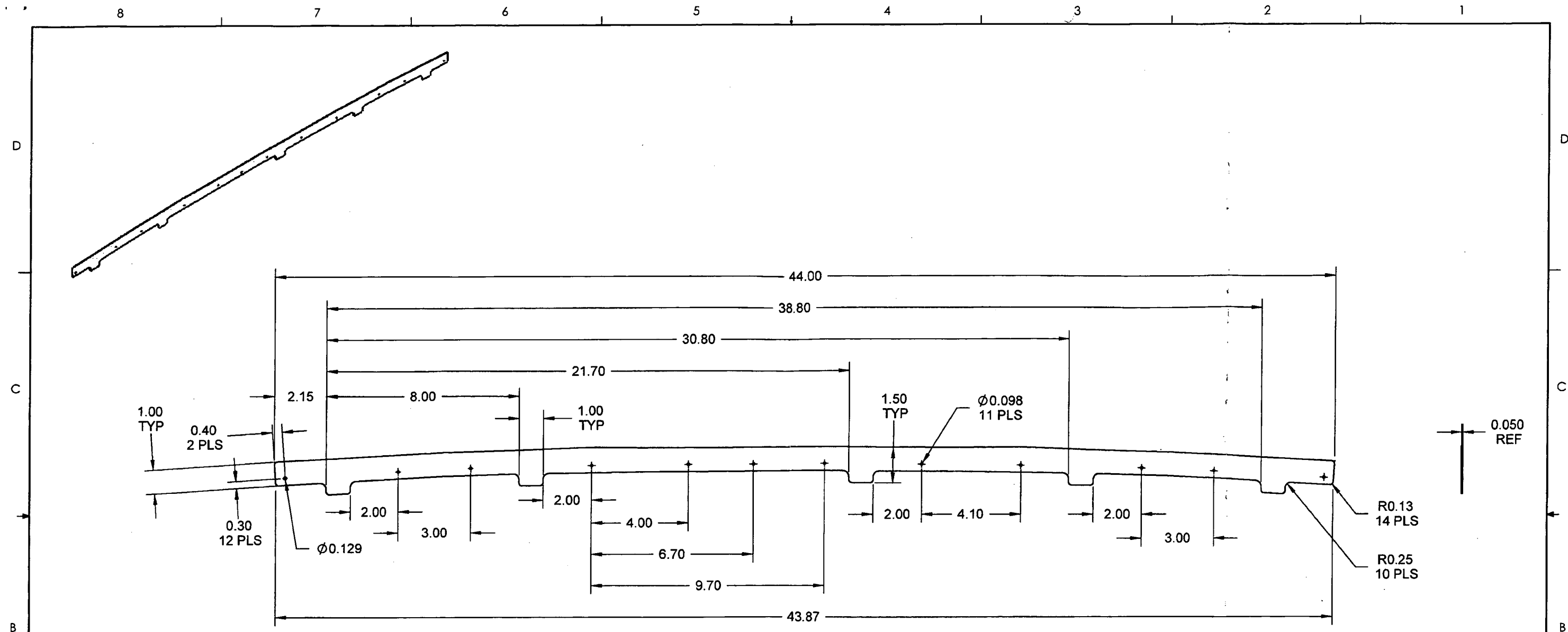
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	+ .004 - .001	.100	X			
.30	± .030	.301	X			
.40	± .030	.391	X			
1.00	± .030	.999	X			
2.15	± .030	2.15	X			
Ø .124	+ .005 - .001	130 .125	✓			
2.00	± .030	2.00	X			
3.00	± .030	3.001	X			
2.00	± .030	2.00	X			
4.00	± .030	3.994	X			
6.70	± .030	6.707	X			
9.70	± .030	9.70	X			
2.00	± .030	1.994	X			
4.10	± .030	4.098	X			
2.00	± .030	2.00	X			
3.00	± .030	3.003	X			
8.00	± .030	8.00	X			
1.00	± .030	.995	X			
21.70	± .030	21.70	X			
30.80	± .030	30.80	X			
38.80	± .030	38.80	X			
44.00	± .030	44.00	X			
.050	± .010	.050	X			

Measured by: FB	Audited by: S	Prototype Approval: n/a
Date: 8-8-13	Date: 08/08/13	Date: 8/4

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D3797-1 GROUND PLATE

NOTES:

- 1) MATERIAL: 5052-H32 (QQ-A-250/8) OR 6061-T6 (QQ-A-250/11) ALUMINUM SHEET 0.050 THICK (REF. DART SPEC. M5052H32S.050 OR M6061T6S.050)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.08 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40488

A	NEW ISSUE	RF	08.05.26
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	RF	D3797	SHEET 1 OF 1
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	GROUND PLATE	NTS
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